Work Order ID 53590

November 9, 2009 11:22:30 AM

Item ID: D3845-1KGY
Revision ID: C
Item Name: Hat Bin-Grey
Start Date: 09/11/2009 **Start Qty:** 4.00
Required Date: 13/11/2009 **Req'd Qty:** 4.00
Reference:

Accept

Setup Start
Stop

Cust Item ID:
Customer:

Approvals: **Process Plan:** BB **Date:** 04-11-9 **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**									
100		0.00							
HandThermo	**Memo**	0.00							
Hand Finishing Thermoforming	1-Machine set up								
	2- Cut sheet to required blank size M111807								
110		0.00							
Thermoform	**Memo**	0.00							
Thermoforming Machine	Thermoform as per Dwg. D3845 and folio (FTA9255 Prototype) using tool DT 9255								
	Dwg. Rev. C Folio Rev. B								

BB 09/11/2Y XY

BB 09/11/2Y XY

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							BB 09/11/2y
QC	Memo	0.00							X 3
Quality Control									X1 SCRAP
									PTO →
130	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00				X3	4		
Quality Control									
140		0.00							BB 09/11/30
HandThermo	Memo	0.00							X 3
Hand Finishing Thermoforming	1) Trim to Finished Dimensions								

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		D206-781-371 KGY					

Part No: D3845-1 KGY PAR #: N/A. Fault Category: Thermal Spray NCR: (Yes) No DQA: [illegible] Date: 09.12.08

Resolution: Scrap Disposition: Scrap. QA: N/C Closed: // Date: 05.12.11

NCR: 53590		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B: Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
09/11/30	120	To Much Moisture in Sheet R.C. Process	Cosmer	Scrap and Destroy No Replace	09/12/01	S 09/12/01	Cosmer	S 09/12/01

NOTE: Date & initial all entries

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Run Start
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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC2- Inspect parts off machine FAI/FAIB	0.00							09/11/30
QC	Memo	0.00							
Quality Control									
160	QC5- Inspect part completeness to step on W/O	0.00				43	0		
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location:_____	0.00				9/12/11			3x5
Packaging	Memo	0.00							
Packaging									

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Setup Start
Stop

Cust Item ID:
Customer:

Run Start
Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00				_____	09/12/03		MF
QC	**Memo**	0.00							09-12-03
Quality Control									

Status	Item ID	Rev	Name	Start Date	Quantity Per	UOM	Op	Date	Scrap	Qty	Mfg	Lead	NEC	ECX	Sort	Mfg	Offset	Type	Per	Cch	to	Store	Cat	Last
✓	MKYD6185S.125-P3-52068		Kydex steel grey	06/24/09	11.4100	sf		100	5	0.					1		0	M						06/...

BB 09/14/24
X4

DART AEROSPACE LTD	Work Order:	53590
Description: Hat Bin	Part Number:	D3845-1KIV/KGY
Inspection Dwg: D3845 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [] Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than ____"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

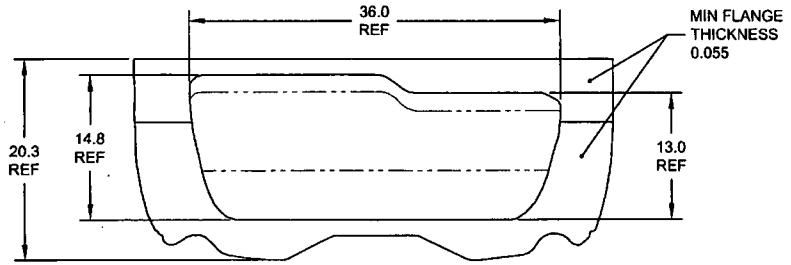
Measured by:	BB	Date:	09/11/30

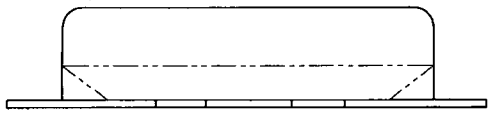
TRIMMING SECTION

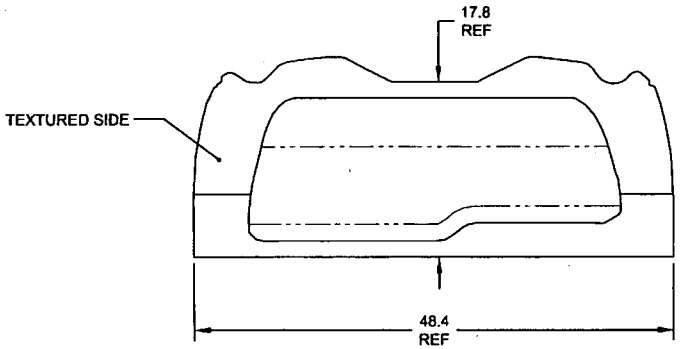
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.5	Min	.516	✓			
0.055	Min	.104	✓			
0.030	Min	.041	✓			

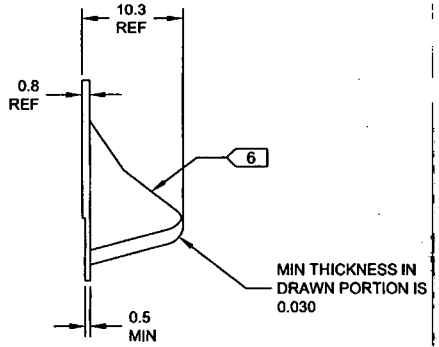
Measured by:	BB	Date:	09/11/30
Audited by:	[illegible]	Date:	09/12/01
Prototype Approval:	N/A	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.06.26	New Issue	KJ	









SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 533590

09-11-9

RELEASED
09/05/22

D3845-1 HAT BIN
(BELL 206 L/L1)

NOTES:
1) MATERIAL: SEE TABLE
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
7) WEIGHT: 5.3 lbs
8) TOOLING: THERMOFORM PER MOLD DT9253 PER DART QSI 022. TRIM PER MOLD

	PART NUMBER	DESCRIPTION
C	D3845-1KIV	KYDEX 6185, 0.125 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.125-P3-62015)
C	D3845-1KGY	KYDEX 6185, 0.125 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.125-P3-52068)

REV.	DESCRIPTION	BY	DATE
C	ADD STEEL GRAY COLOUR OPTION, ADD IVORY P/N D3845-1KIV AND ADD STEEL GRAY P/N D3845-1KGY (ZN A5-1)	PH	09.05.05
B	0.125 THICK WAS 0.080 (ZN A7-1) REASON: TO IMPROVE DURABILITY	PH	09.02.19
A	NEW ISSUE	PH	08.10.22

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. REV. C
MFG. APPR.		D3845 SHEET 1 OF 1
APPROVED		TITLE SCALE
DE APPR.		HAT BIN (BELL 206 L/L1) NTS
DATE	09.05.05	

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